

Date: Tuesday, 4/25/2006 1:55:32 PM
 User: Kim Johnston

SPLIT

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : BLADE FITTING
 Job Number : 26839
 Estimate Number : 12300
 P.O. Number : N/A
 This Issue : 4/25/2006 S.O. No. : N/A
 Prsht Rev. : NC
 First Issue : N/A Type : MACHINED PARTS
 Previous Run : 26190
 Part Number : D3488042
 Drawing Number : D3488 REV B
 Project Number : N/A
 Drawing Revision : B
 Material : N/A
 Due Date : 5/20/2006 Qty: 18 Um: Each
 Written By : SEE COMMENT BELOW
 Checked & Approved By : 06.04.25
 Comment : Est Rev:A New Issue 06-02-28 JLM
 Est Rev:B As per Rev B 06-03-30 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 D6103003 alum billet



Comment: Qty.: 1.0000 Each(s)/Unit Total: 20.0000 Each(s)

Aluminum Round Billet D6103-003

Batch: 325806 27033

2.0 MORI SEIKI MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Turn as per Dwg DSK 101 & Folio FA627

Issue Po to Meter 1110
 turn per DSK 101 Rev. C u 06-04-27

2-Deburr

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.G 06/05/30 x1

4.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine as per Folio FA627 & Dwg D3488

2-Deburr

J.G 06/05/30 x1

5.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.G 06/05/30 x1

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Job Number: 26839

Part Number: D3488042

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

66105.134 x 1

7.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

a.m 06-05-31

(1)

8.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

a.m 06-05-31

(1)

9.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

DL 06/05/31

(1)

10.0	ALS71032225	INSERT
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 80.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 ALS7-1032-225 Insert M100489

DL 06/05/31

(1)

11.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Install Inserts as per Dwg D3488

DL 06/05/31

(1)

12.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

FC 06 06 01

(1)

13.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FP24

DL 06/05/01

(1)

Process Sheet

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Drawing Name: BLADE FITTING

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Part Number: D3488042

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SP 060601

Job Completion



le 060601

DART AEROSPACE LTD		Work Order:	26839
Description: Blade Fitting, RH		Part Number:	D3488-2
Inspection Dwg: D3488	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.125	+/-0.010	0.125	✓			
2.620	+/-0.010	2.621	✓			
0.793	+/-0.010					Remar / cannot measure correctly,
1.351	+/-0.010	1.348	✓			
1.317	+/-0.010	1.321	✓			
90°	+/-0.1°	90°	✓			
1.802	+/-0.010	1.802	✓			
Ø0.508	+0.006/-0.001	0.508	✓			
R0.062	+/-0.010	R0.062	✓			
1.500	+/-0.010	1.499	✓			
8.000	+0.030/-0.000	8.006	✓			
11.18	+/-0.030	11.179	✓			
Ø0.484	+0.005/-0.001	0.484	✓			
1.180	+/-0.010	1.180	✓			
3.150	+/-0.010	3.150	✓			
3.070	+/-0.010	3.069	✓			
0.590	+/-0.010	0.589	✓			
0.125	+/-0.010	0.120	✓			
1.005	+/-0.010	1.005	✓			
3.500	+/-0.010	3.498	✓			
Ø0.297	+0.005/-0.000	0.297	✓			
Ø0.430	+/-0.010	0.425	✓			
0.100	+/-0.010	0.095	✓			

Measured by: J.G	Audited by: En	Prototype Approval:	N/A
Date: 06/05/31	Date: 06/05/31	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.03.31	New Issue	KJ/JLM	<i>[Signature]</i>

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1914



CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
46	DSK101	Blade Fitting	1110

MATERIAL: supplied by DART

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

Shigi (Regula) Walz

Vankleek Hill, May 24, 2006



